

Date: Wednesday, 9/26/2007 2:09:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK FRAME ASSEMBLY
Job Number : 34895	
Estimate Number : 11129	
P.O. Number :	Part Number : D3017041
This Issue : 9/26/2007 S.O. No. :	Drawing Number : D3017 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 33364	Material :
Written By :	Due Date : 10/15/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. A 01.09.19 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)

4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall

Batch: 1103092

PD 08-04-17

2.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)

4130 Sheet .049 wall

Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)

Batch: 111612

PD 08-04-17

3.0	D30177	Lug
-----	--------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
3	D3017-7	Lug	<u>B22411 -> 1</u>

B38567 -> 2

PD 08-04-17

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Cut end caps as per Dwg D3017

3-Weld as per Dwg D3017 using Welding Jig Dt8598

A/R Steel Rod Batch: 1100015

PD 08-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:09:13 PM
User: Kim Johnston

Process Sheet

30 min

18/04/2008

S.052 06:07

#1 325.7 F

#3 34875 F

D.307041 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 34895

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill D3017-041 Using DT8621

5-Deburr

PD 08-04-17

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MA 08/04/17

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 08/04/17

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR 08-04-18

①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23 ①

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/04/23 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 ①

Job Completion



MF 08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



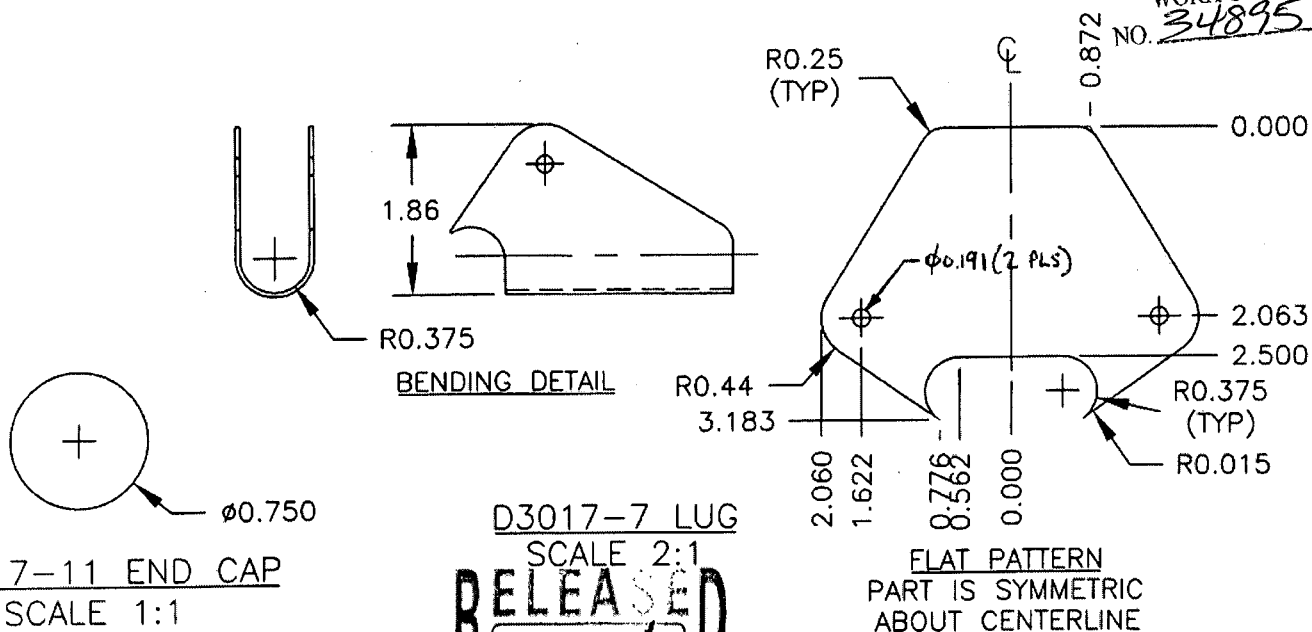
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

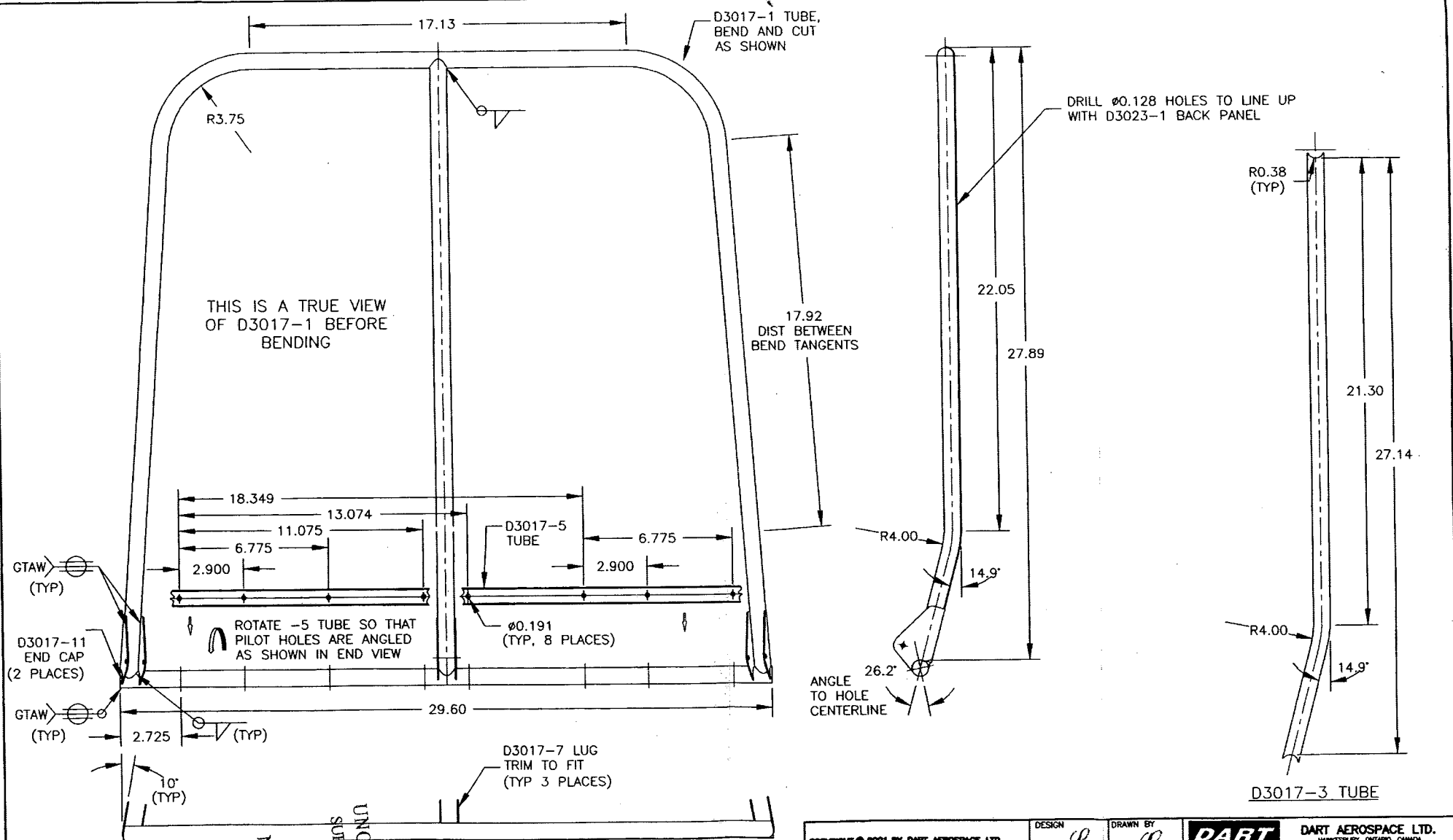
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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01-06-07

NO. 34895
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D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3017	REV. A SHEET 2 OF 2
DATE 01.05.18	TITLE BACK FRAME ASSEMBLY	SCALE 1:4	